

September-11-14 11:58:54 AM

Page 1

**Accept**

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 9/10/14      **Start Qty:** 4.00      **\*4\***

**Cust Item ID:**

**Required Date:** 9/10/14      **Req'd Qty:** 4.00      **\*4\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_      **Run**      **Start**      **\*NR1\***  
                  **QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_      **Stop**      **\*NR2\***

100			0.00				DAS 23 <del>9-89</del>	14-10-27
*100*	FLOW WATER JET							
Waterjet	Memo		0.00					
FLOW CNC Waterjet	1-Cut as per Dwg D2369							
	Dwg Rev: B							
	Prog Rev: B							
	2-Deburr if necessary							
110								
	QC2- Inspect parts off machine FAI/FAIB		0.00				DAS 23 <del>9-89</del>	14-10-27
*110*								
QC	Memo		0.00					
Quality Control								

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**Work Order ID 124217**

September-11-14 11:58:54 AM

**\*124217\***

Page 2

Item ID: D2369-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Locator Plate  
Start Date: 9/10/14 Start Qty: 4.00 **\*4\*** Cust Item ID:  
Required Date: 9/10/14 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC8- Inspect parts - second check	0.00							
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**\*120\***

QC

Memo

0.00

Quality Control

OCT 2 8 2014

130	Identify as per dwg & Stock Location <i>57225B</i>	0.00							
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**\*130\***

Packaging

Memo

0.00

Packaging

DAS  
26  
9-89

OCT 2 8 2014

140	QC21- Final Inspection - Work Order Release	0.00							
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**\*140\***

QC

Memo

0.00

Quality Control

*14/10/29*  
*14-10-29*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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September-11-14 11:58:54 AM

**Work Order ID:** 124217

**\*124217\***

**Parent Item:** D2369-1

**\*D2369-1\***

**Parent Item Name:** Locator Plate

**Start Date:** 9/10/14**Required Date:** 9/10/14

**Start Qty: 4.00**

**Required Qty: 4.00**

**Comments:**

IPP Rev A    Removed from 9 Digit    05-12-05    JLM

IPP Rev:B now water jet 07-12-11 DD

13.05.21 AS PER DWG REV.B VERF:JLM

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	115.7000	1.354	6			
												DAS 23 9-89	14-10-27
<div> <div>*M5052H32S 040*</div> <div>5052-H32 .040 Sheet</div> </div>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT022		115.7							
				122406		9.8							
				124445		1.4							
				124573		2							
				m128852		22.5							
				m129530		80							
									128852				

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Work Order update only ☐

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Material									
Operator									
Offset/Setup									
Process									
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Training									
Transport									
Unapproved									

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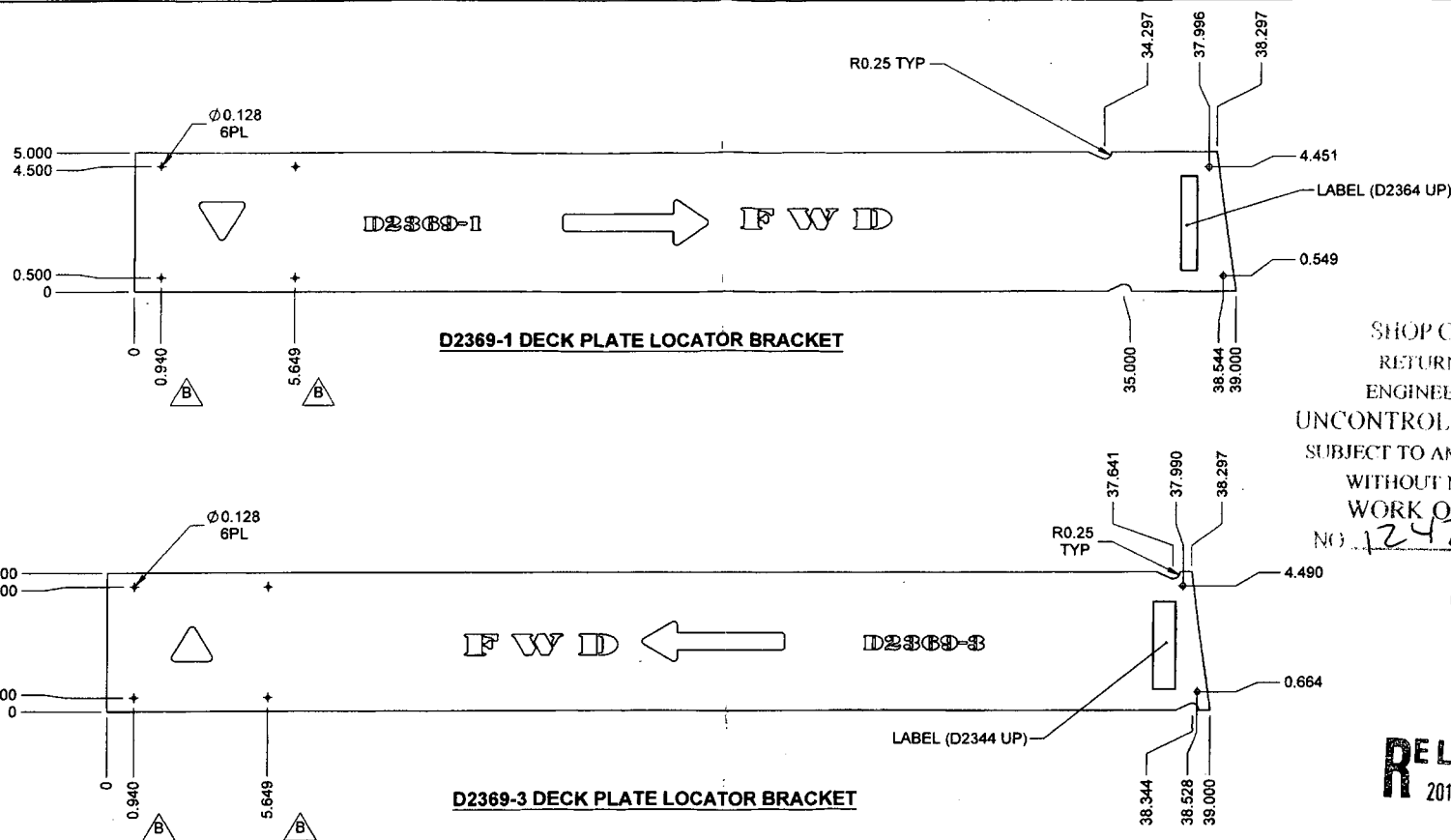
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	124217
<b>Description:</b> Deck Plate Locator Bracket		<b>Part Number:</b>	D2369-1
<b>Inspection Dwg:</b> D2369 <b>Rev:</b> B			<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

DAS		38			
Measured by:	23 9-89	Audited by:	9-89	Preliminary Approval:	
Date:	14-10-27	Date:	2007-09-20	Date:	

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	13.06.27	Dimensions revised per Dwg Rev B	KJ	



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO 124217115  
14-09-16

RELEASED  
2013-05-16

# NOTES:

- 1) MATERIAL: 6061-T6 SHEET, 0.040" THICK PER QQ-A-250/11, AMS-QQ-A-250/11, AMS 4025, AMS 4027 OR ASTM B209 (REF: DART SPEC M6061T6S.040) OR 5052-H32 ALUMINUM SHEET, 0.040" THICK AS PER QQ-A-250/8 OR AMS-QQ-A-250/8 OR AMS 4016 OR ASTM B209 (REF: DART SPEC M5052H32S.040)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) PROFILE PER DRAWING FILE "D2369-1-REV.B.DXF" OR "D2369-3-REV.B.DXF"

B	DRAWING RE-FORMATTED TO NEW STANDARD, 5052-H32 WAS 5052-H34, ADD 6061-T6 MATERIAL OPTION (ZN A8-1) 0.940 WAS 1.000, 5.649 WAS 5.709 (ZN B6-1, ZN B7-1, ZN C6-1, ZN C7-1), REF CIRTS-15	DB	13.03.22
A	NEW RELEASE	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	2/1	D2369	SHEET 1 OF 1
APPROVED	1/2	TITLE	SCALE
DE APPR.	1/2	DECK PLATE LOCATOR BRACKET	NTS
DATE	13.03.22	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	